

Work Order ID 52655

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October 5, 2009 2:53:04 PM

Item ID: D2528-1

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Backer Plate

Start Date: 06/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	Barcode
	QC:	Date:	SPC (Y/N):	Date:		Stop	Barcode

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2528	Rev C1

100 0.00



FLOW WATER JET

Waterjet

Memo 0.00

1B 9-11-6

FLOW CNC Waterjet

S652
.8631-Cut as per Dwg D2528 Dwg Rev: C1 Prog Rev: C1 2-
Deburr if necessary

110 0.00



QC2- Inspect parts off machine FAI/FAIB

Memo 0.00

1B 9-11-6

QC

Quality Control

120 0.00



QC8- Inspect parts - second check

Memo 0.00

27

QC

Quality Control

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Chemical Conversion Coat per QSI005 4.1

0.00

M 09/16/10

Y27 8

HandFinish

Memo

0.00

Hand Finishing

140



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 11/21/08

Y27 5

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:00AM OVEN TEMPERATURE:
10:30AM FINISH TIME: 320°F

150



QC3- Inspect Part Finish

0.00

M 09-11-12

Y27 5

QC

Memo

0.00

Quality Control



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October 5, 2009 2:53:04 PM

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Setup Start



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Stop



Item Name: Backer Plate

Start Date: 06/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

9/11/13 07 sf

170

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

09/11/13 JJ
MF 09-11-13

Picklist Print

Page 1

October 5, 2009 2:53:03 PM

Work Order ID: 52655



Parent Item: D2528-1RevC1



Parent Item Name: Backer Plate

Start Date: 06/10/2009

Required Date: 13/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased		No		100	sf	129.3237	0.3189	1		

5052-H32 .063 Sheet

Warehouse Loc Qty Loc CodeLocation

Main Warehouse

MAT	129.3237	
103755	1.3237	
107276	32	
112442	96	

107276

27

DART AEROSPACE LTD	Work Order:	52655
Description: Backer Plate	Part Number:	D2528-1
Inspection Dwg: D2528	Rev: C1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	BS	Audited by:		Prototype Approval:	N/A
Date:	9-11-09	Date:	GS 11-09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.03.10	New Issue	KJ/DD	

DART



DESIGN <i>KE</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>MM</i>	DRAWING NO. D2528	REV. C SHEET 1 OF 1
DATE 98.12.10		TITLE BACKER PLATE	SCALE 1:1
A	96.12.12	NEW ISSUE	
B	97.10.10	CHANGE SIZE AND HOLE LOCATION	
C	98.12.10	ADD D2528-1 AND -3 (TSR A1037) UPDATED TOLERANCES	
CI	05.04.27	1.46 WAS 1.460; 1.00 WAS 1.000	

RELEASED
98.12.11 *KE*

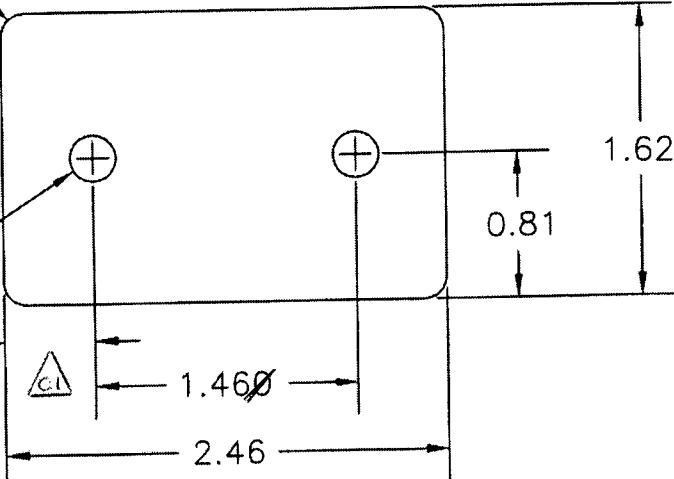
R0.13 (TYP)

UNDER REVIEW

OK 03.12.03

$\phi 0.257$ (TYP)

0.50



D2528-1

R0.13 (TYP)

$\phi 0.257$ (TYP)

0.73

1.000

2.46

D2528-3

SHOP FOR

RELEASING

ENGINEER

UNCONTROLLED

SUBJECT TO AMENDMENT

WITHOUT

WORK

NO. 52655

21/02/10-5

MATERIAL: 5052-H32 OR 5052-H34 (QQ-A-250/8) OR 2024-T3
(QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED